Quality Control

Page 1

B 10-2-12

February 12, 2010 8:13:00 AM Accept Setup Start Item ID: D3929-041 **Revision ID:** Stop Item Name: Gusset Assembly Start Qty: 6.00 Cust Item ID: **Start Date:** 2/12/10 Required Date: 2/19/10 **Req'd Oty:** 6.00 **Customer:** Reference: Start Run Date: 10-2-12 Tooling: **Process Plan:** Date: Approvals: Stop Date: SPC (Y/N): Date: QC: Reject Accept Reject Insp. Operation Set Up/ Draw Sequence ID/ Qty Rev. Qty Number Stamp Description Number Code **Work Center ID Run Hours** Draw Nbr **Revision Nbr** D3929 Rev A 0.00 100 B 10-2-12 0.00 Waterjet Memo 1-Cut as per Dwg D3929 FLOW CNC Waterjet Dwg Rev: Prog Rev: 2-Deburr if necessary QC2- Inspect parts off machine FAI/FAIB 0.00 110

0.00

Memo

Dart Aerospace Ltd	1
--------------------	---

W/O:			W	ORK ORDER CHANG	iES			
DATE STEP			OCEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes I	No DQA:	Date: _	
	R	esolution:	Dispositio	n:	_ QA: N/C Cld	sed:	Date: _	
NCR:	-		WORK ORD	ER NON-CONFORMA	ANCE (NCR			
DATE STE	STEP	Description of NC			ion B	Verification	Approval	Approval
DAIL	JILI	STEP Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
								-
						į		
!	1							

### Work Order ID 56180



Page 2

February 12, 2010 8:13:00 AM

Item ID:

D3929-041

Accept

Setup Start

Stop



**Revision ID:** 

Item Name:

Gusset Assembly

Start Date: Required Date: 2/19/10

2/12/10

QC:

Start Qty: 6.00

Req'd Qty: 6.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

Date:

Date:

Run Start

Stop



Sequence ID/

**Work Center ID** 

120

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Set Up/

SPC (Y/N):

**Run Hours** 

Sidalis

0.00

Draw Number

Draw Rev.

Plan Code

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

130

Packaging

**Packaging** 

Pick Kit

Memo

0.00

0.00

0.00

0.00

140

Large Fab Large Fab

Memo

Weld bushings D3907-1 as per dwg D3929

316L rod batch: 109213

CDC 10.03.01

Dart Aerospace	Ltd
----------------	-----

	•								r
W/O:			WC	ORK ORDER CHANGI	ES				
DATE	STEP	PRO	PROCEDURE CHANGE					Approval Chief Eng / Prod Mgr	Approval QC Inspector
							,		
								į	
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	_ Date: _	
	Re	esolution:	Disposition	Disposition: QA: N/C Closed: Da					
NCR:		·	WORK ORDI	ER NON-CONFORMA	NCE (NCF	R)			
DATE	STEP	Description of NC	Corrective Action Section B			Verific	cation Approval	Approval	
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti	on C	Chief Eng	QC Inspector
				·	,				
							:		

#### Work Order ID 56180



Page 3

February 12, 2010 8:13:00 AM

Item ID:

D3929-041

Accept

Setup Start

Stop



**Revision ID:** 

Item Name:

Gusset Assembly

**Start Date:** 

2/12/10

QC:

Start Qty: 6.00

Req'd Qty: 6.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

**Process Plan:** 

Date:

**Tooling:** 

Date:

Run Start

Required Date: 2/19/10

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ **Work Center ID** 

150

Quality Control

Operation Description

QC9- Inspect visual per QSI004- Fusion Welds

Memo

Memo

Set Up/ **Run Hours** 

0.00

Draw Number

Draw Rev.

Plan Accept Qty Code

Reject Reject Qty

Insp. Number Stamp

0.00

(G)

PD 10.03.01

160

QC

Quality Control

QC5- Inspect part completeness to step on W/O

8 20/03/01

0.00

Identify as per dwg & Stock Location:



170

Packaging

Memo

0.00

PD 10.03.02

Packaging

## **Dart Aerospace Ltd**

		— - <del>- • •</del>								· .
W/O:			W	ORK ORDER CHANG	ES					,
DATE	STEP	PRO	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No: PAR #:		PAR #:	Fault Cate	egory:	_ NCR: Ye	es N	o <b>DQ</b>	A:	Date:	
	Re	esolution:	Disposition	Disposition: Q/					Date:	
NCR:			WORK ORD	PER NON-CONFORM	ANCE (N	CR)				W.C=0.
DATE	STEP	Description of NC	Corrective Action Section B			Sign & Sect		cation Approval		Approval
		Section A	Initial Chief Eng	Action Description Chief Eng		n & ite	Secti	on C	Chief Eng	QC Inspector
									•	

### Work Order ID 56180



Page 4

February 12, 2010 8:13:00 AM

Item ID:

D3929-041

Accept



Setup Start

Stop

Start



**Revision ID:** 

Item Name:

Gusset Assembly

**Start Date:** Required Date: 2/19/10

2/12/10

QC:

Start Qty: 6.00

**Reg'd Oty:** 6.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Date:

**Tooling:** 

Date:

Stop

Run

**Process Plan:** 

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID

180

Operation Description

OC21- Final Inspection - Work Order Release

Set Up/ **Run Hours** 

Draw Number

Draw Rev.

Plan Accept Code Qty

Reject Qty

Reject Insp. Number

Stamp

**Quality Control** 

Memo

0.00

0.00

AH10-3-02

Dart Aerosp	ace Ltd
-------------	---------

W/O:			W	ORK ORDER CHANG	3E6					
DATE	STEP	PRO	OCEDURE CHA		JLJ	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					1					
Part No	:	PAR #:	Fault Cate	gory:	NCF	R: Yes N	lo DQA	<b>\</b> :	Date:	
	R	esolution:	Dispositio	n:	QA:	N/C Clo	sed:		Date:	
NCR:			WORK ORD	ER NON-CONFORM	ANCE	(NCR)		-	71-11	<u>.</u>
DATE STEP		Description of NC	Description of NC Corrective Action			· · · · · · · · · · · · · · · · · · ·			Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section		Chief Eng	QC Inspector
					•					
									-	

#### **Picklist Print**

February 12, 2010 8:13:05 AM

Work Order ID: 56180

D3929-041 Parent Item:

Parent Item Name: Gusset Assembly

**Comments:** 



**Start Date: 2/12/10** 

Start Qty: 6.00

Required Date: 2/19/10

Page 1

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq'ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No		, <u>, , , , , , , , , , , , , , , , , , ,</u>	100	sf ,	81.7878	2.8421		B (0-9-1	<b>)</b>

Warehouse	Loc Oty	Loc Code
<b>Location</b>		
Main Warehouse		
MAT	81.7878	
112663	81.7878	

130

62.0000 12.0000 Each

Warehouse	Loc Qty	Loc Code	
<b>Location</b>			
Main Warehouse			
WA	62		
54042	21		
55104	41		(72)



112663

D3907-1

Bushing

Manufactured

Dart Aerospace	Ltd
----------------	-----

	•								
W/O:			WC	RK ORDER CHANG	ES	• • • • • • • • • • • • • • • • • • • •			
DATE	STEP	PR	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
						÷			
Part No		PAR #:							
	Res	solution:	Disposition	1:		Date: _	<del></del>		
NCR:			WORK ORDI	ER NON-CONFORMA	ANCE (NC	R)			
DATE	STEP	Description of NC Corrective Action			Verit			Approval	Approval
	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Dat	l&i Sec	tion C	Chief Eng	QC Inspector
									-

DART AEROSPACE LTD	Work Order:	56180
Description: Support Gusset	Part Number:	D3929-1
Inspection Dwg: D3929 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing	T.1	Actual			Method of	_
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
Ø0.375	+0.006/-0.001	1377	Ø			
0.500	+/-0.010	207,	ک			
0.500	+/-0.010	,500	<b>≫</b>			
4.036	+/-0.010	4.039	×			
4.382	+/-0.010	4.280	*			
8.274	+/-0.010	8,277	×			
10.915	+/-0.010	10,93	K			
1.000	+/-0.010	8001	*			
11.198	+/-0.010	11.700	~			
0.500	+/-0.010	1501	*			
1.572	+/-0.010	1.576	Ÿ			
0.125	+/-0.010	in	y			
• •						

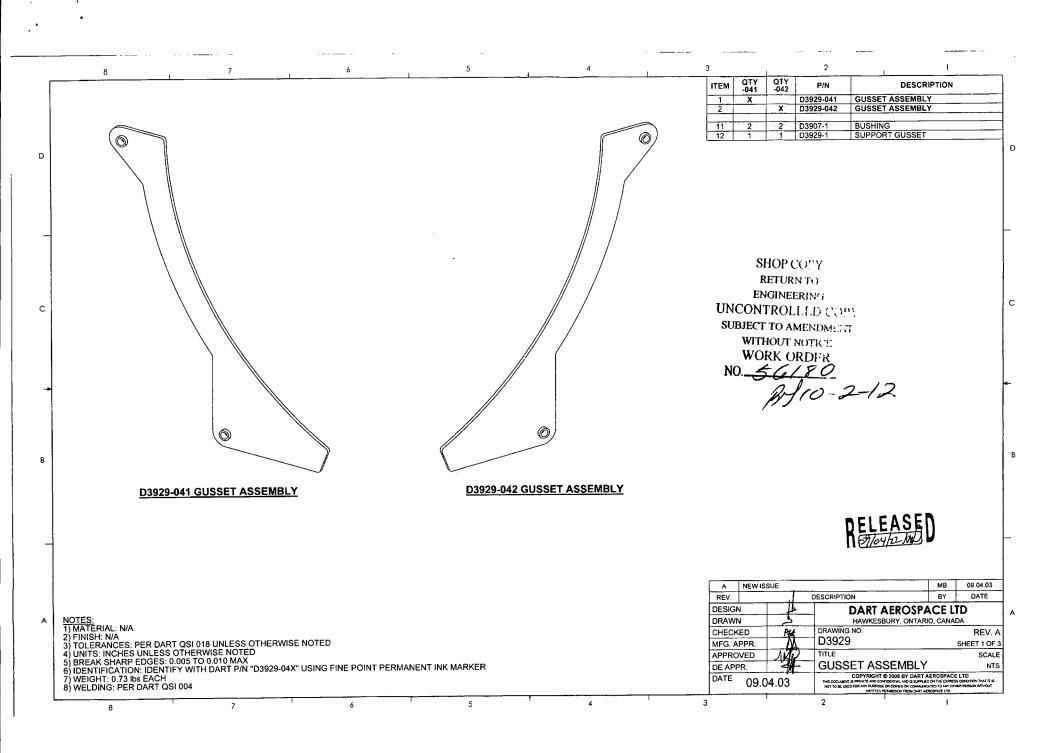
Measured by:	B	Audited by:	8	Prototype Approval:	N/A
Date:	10-9-17	Date:	062 16	Date:	N/A

Rev	Date	Change		Revised by	Approved
Α	09.05.27	New Issue	P/O D3929-041/-042	KJ X	13

Dart	Aer	osp	ace	Ltd
------	-----	-----	-----	-----

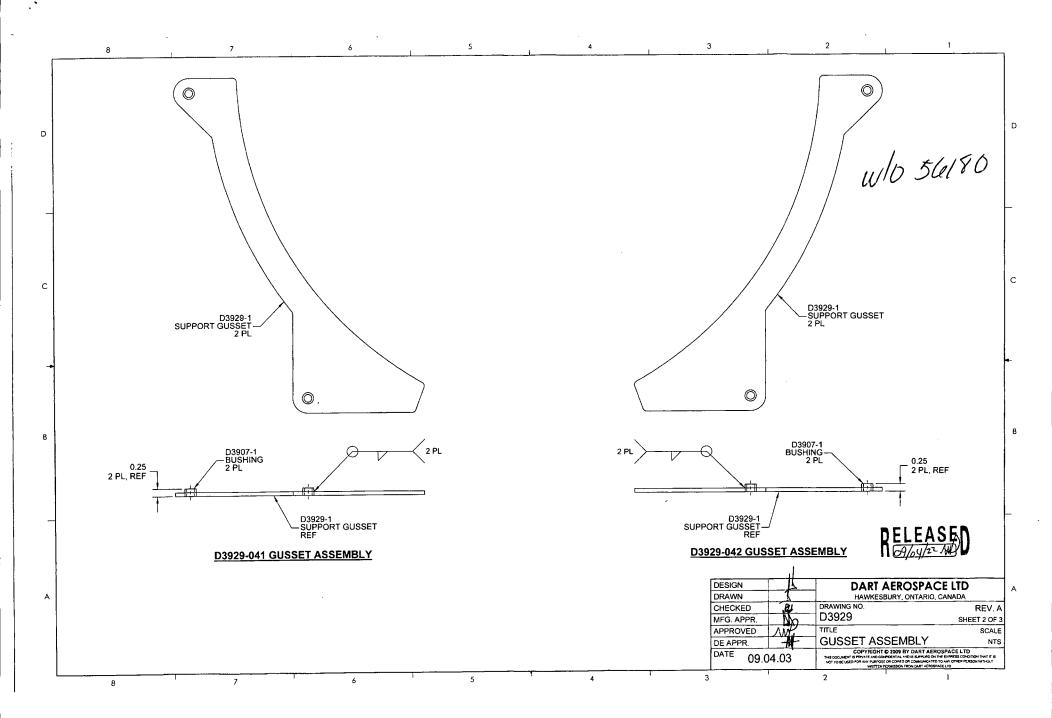
W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
								•				
Part No:		PAR #:	Fault Cate	egory:	NCR: Yes No DQA: Date:							
Resolution: Disposition:				_ QA: N/C Cld	osed:		Date:	· · · · · · · · · · · · · · · · · · ·				
NCR:		V	VORK ORD	ER NON-CONFORM	ANCE (NCR	)						
DATE	OTED	Description of NC		tion B	on B Verifica			Approval				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Approval Chief Eng	Approval QC Inspector			
							•					
							:					
							-					
····												
									•			
									·			

NOTE: Date & initial all entries



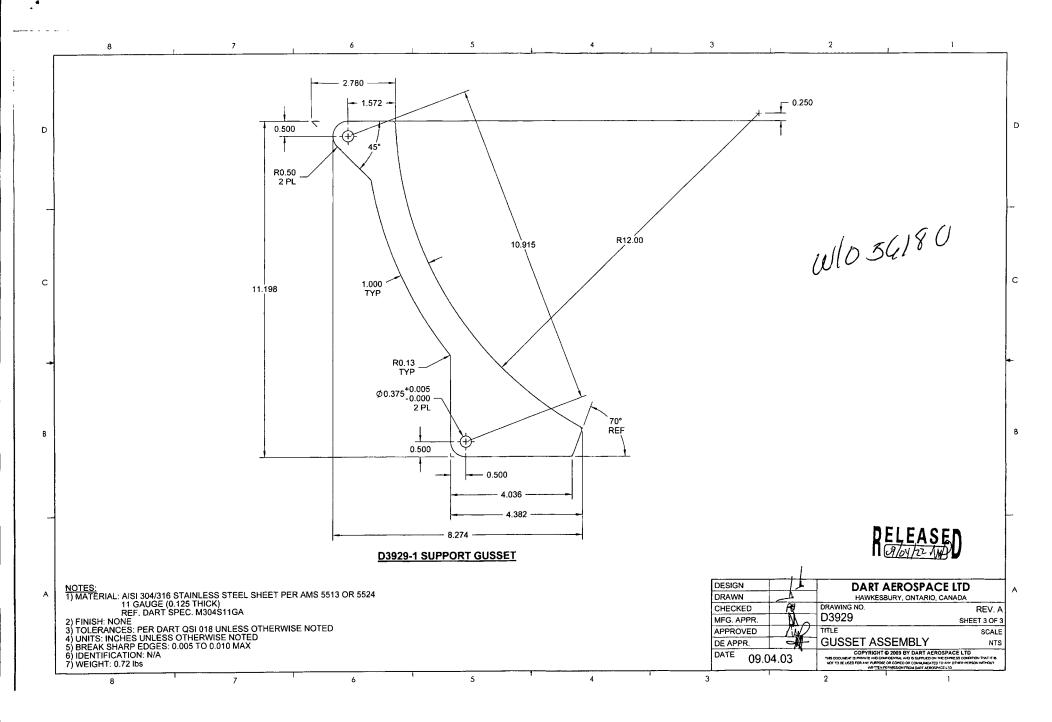
# **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES										
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
								<b>.</b>				
Part No:		PAR #:	Fault Cate	Fault Category: N			NCR: Yes No DQA: Date:					
Resolution: Disposition			n:	_ QA: N/C CI	osed:		Date: _					
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NCF	?)						
DATE	STEP	Description of NC		Corrective Action Section		Verification		Approval	Approval			
	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Sectio		Chief Eng	QC Inspector			
									·			
							'					
								•				



Dart Aerospace I	Ltd
------------------	-----

	-								_			
W/O:		WORK ORDER CHANGES										
DATE	STEP	PR	PROCEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _				
Resolution:			Dispositio	Disposition: QA: N/C Closed: Date:								
NCR:		,	WORK ORDI	R NON-CONFORM	ANCE (NC	7)			_			
DATE	STEP	Description of NC			Section B Verif			Approval	Approval			
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Secti	ion C	Chief Eng	QC Inspector			
					- - - - -							
			1						•			



Dart Aerosp	ace Ltd
-------------	---------

										•	
W/O:			W	ORK ORDER CHANG	ES					44.0	
DATE	STEP	PROC	CEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
					:						
Part No	•	PAR #:	_ Fault Cate	egory:	_ NCR:	Yes N	o DQ/	A:	Date:		
Resolution:			Disposition: QA: N/C Closed:					ed: Date:			
NCR:		W	ORK ORD	ER NON-CONFORMA	ANCE	(NCR)					
DATE	STEP	Description of NC		Corrective Action Section B			Verification		Approval	Approval	
DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C		Chief Eng	QC Inspector	
								·			
										·	